

Date: Wednesday, 6/28/2006 10:14:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 27710
 Estimate Number : 12461
 P.O. Number : N/A
 This Issue : 6/28/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : N/A
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.06.28
 Comment : Est Rev A New Issue 06-06-20 JLM

Part Number : D35081
 Drawing Number : D3508 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material : N/A
 Due Date : 7/5/2006 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.2489 sf(s)/Unit Total : 0.4977 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S20GA)
 Batch: M100473

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: Prel
 Prog Rev: Prel

SAP 06:06:28

②

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 06:06:28

②

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAP 06:07:03

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr and form on brake using DT8178 and DT8261 as per Dwg D3508

SAP 06:07:04

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 10:14:19 AM
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Process Sheet

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Drawing Name: WEARPLATE

Job Number: 27710

Part Number: D35081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 07-04 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06-07-05 2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

O.m 06-07-05 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

LB (2) *PO 6/7/6* (2)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/07 (2)
U 06-07-07

Job Completion



Date
Return to PH
Jan

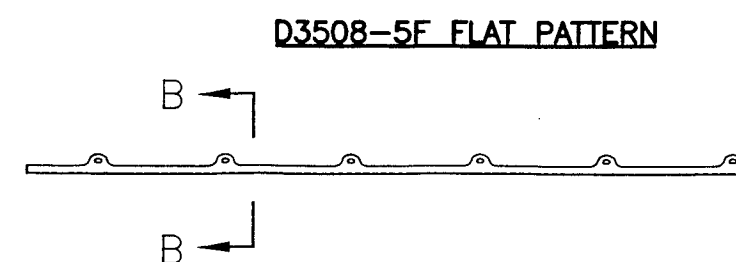
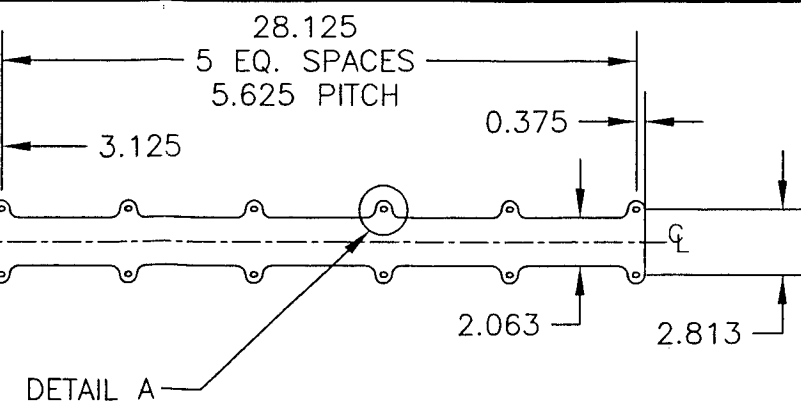
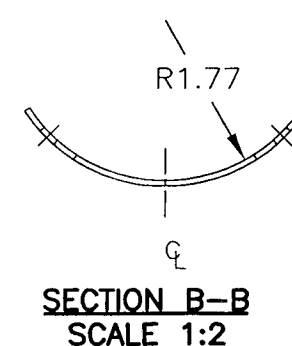
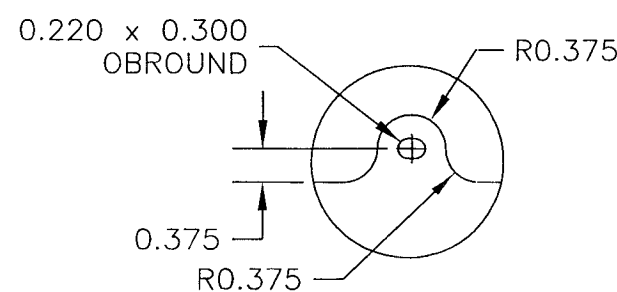
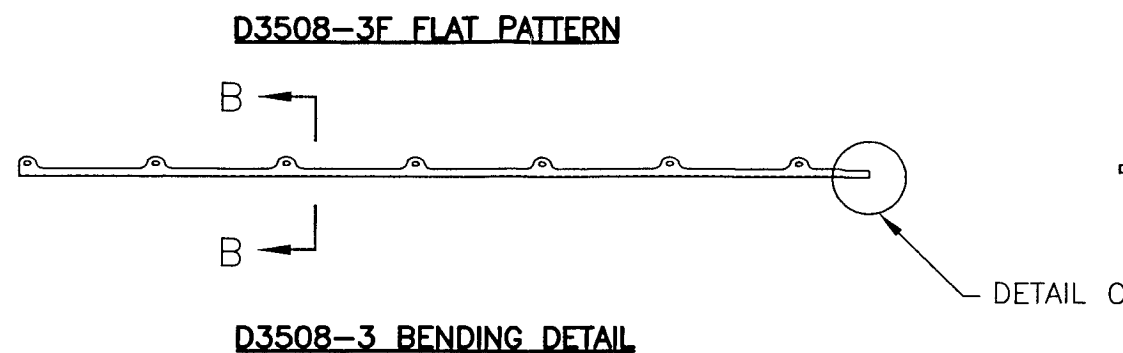
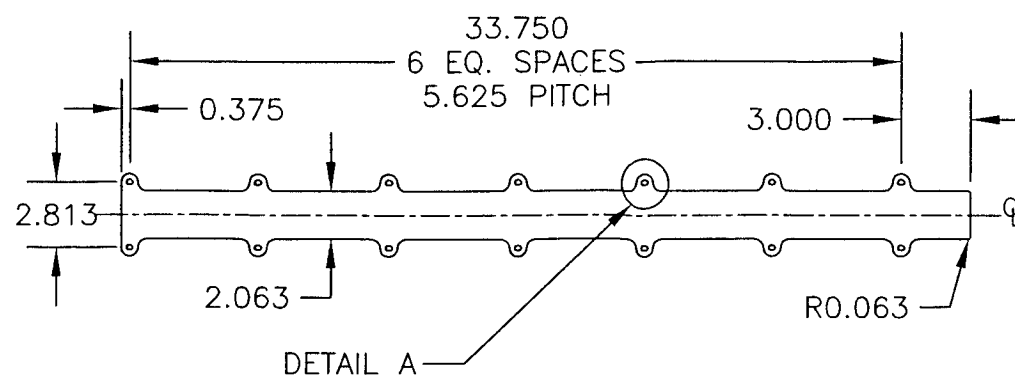
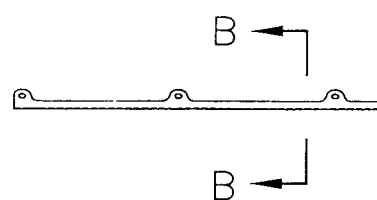
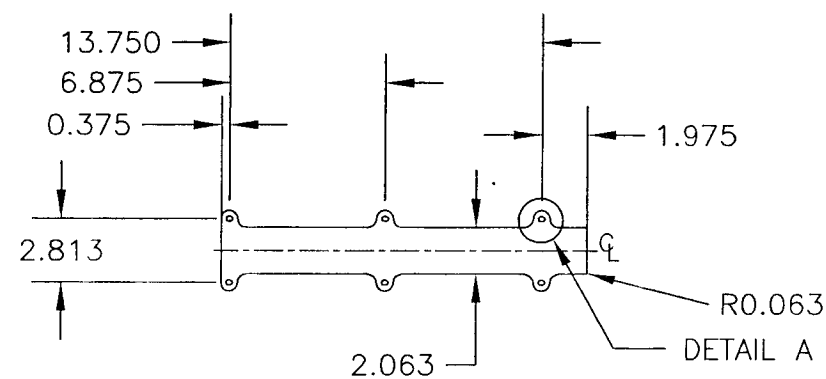
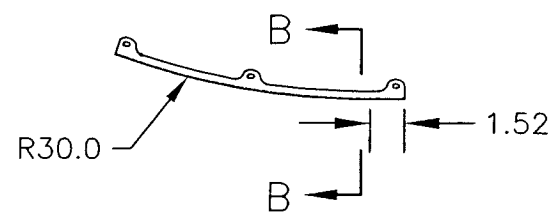
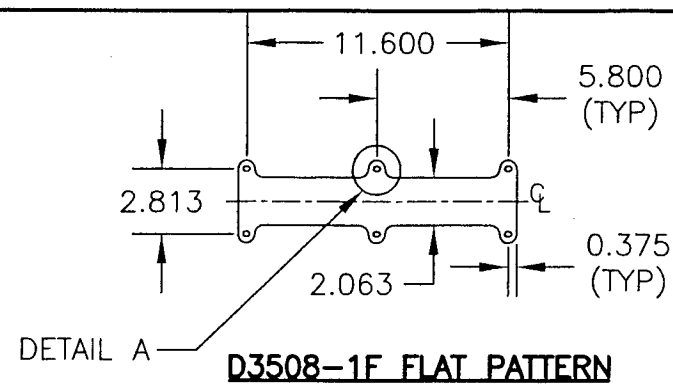
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

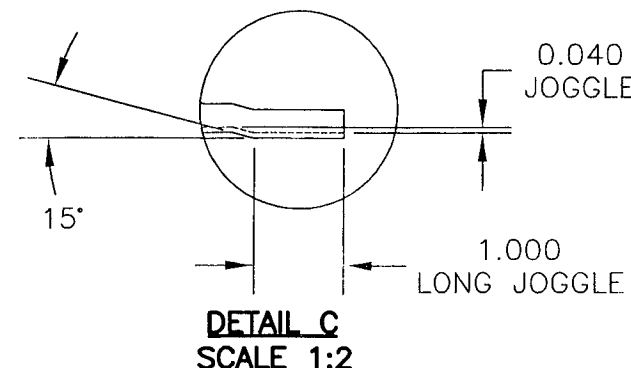
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3508-5 BENDING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27710



D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

PRELIMINARY ISSUE

A		06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED		APPROVED	
DATE	06.04.21	TITLE	WEARPLATE
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		DRAWING NO. D3508	REV. A SHEET 1 OF 1 SCALE 1:1

00100473

	MAZANAS - VENEZUELA	CERTIFICADO DE CALIDAD / MILL TEST CERTIFICATE	PAGINA: 01-A Nº DE CERTIFICADO: 04210437 ID: 28925
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CS TECHINTRADE CORP. 2200 WEST LOOP SOUTH, SUITE 750 HOUSTON, TEXAS 77027.	MONTREAL, CANADA DE SH BI TP I NT OO	OCOMPRAS - Purchase Ord. Nº * OVENTA - RN - Bidor Ord. Nº SA98616 -07 DESPACHO - Shipper Nº FACTURA - Invoice Nº VEHICULO - Vehicle IDA
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PRODUCTO PRIME NEWLY PRODUCED COLD Product SAMUEL. SON & CO J15000 /	ROLLED STEEL COILS TECHINTRADE S.O. 100000217	ASTM A 1008 CS TIPO-B
COLOUR MARK SIZE 0.0550 MIN X 48.000		TIPO DE ANALISIS HEAT PHYSICAL TEST

PHYSICAL TEST					CHEMICAL COMPOSITION - %														
Nº COLADA Heat Nº	Nº DE MUESTRA Sample Identification	TRACCIÓN			DRZ	DOB	C	MN	P	S	SI	CU	AL	MO	NB	V	NI	CR	B
		ESF Y.P	ESF UTS	% AL	-1		-2	-2	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-4
		MFA	MFA	002P	HRB	GRAD													
	MIN.	1.00	2.00	1.00			2						20						
	MAX.				600		15	60	30	35	100	200	80	60	8	8	200	150	10
243097		214.00	312.00	40.00	490	OK	005	028	010	004	023	010	029	004	001	001	011	013	000
544031		215.00	336.00	38.00	500	OK	006	028	009	004	064	002	029	002	001	001	003	006	001
644146		187.00	274.00	38.00	580	OK	007	033	009	001	032	007	023	002	001	001	005	009	000

C43748

OBSERVACIONES / NOTE

SIDERURGICA DEL ORISCO, S.A.
 Gerencia de Gestión de Orden
 en lauding com